

Work Order ID 56952

March 15, 2010 1:27:41 PM



Page 1

Item ID: D3909-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Lower Attach Arm

Start Date: 16/03/2010 Start Qty: 8.00

Required Date: 26/03/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Ref 10.03.15

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 3.455" LONG

MW

18/03/18

8 2

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA872 AND DWG

FOLIO REV: *AA*

DWG REV: *A*

DEBURR

Ref 10.3.20

8

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Page 2

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Date:

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

10.3.20

8



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

L.P. 10/03/20

8



QC

Memo

0.00

Quality Control

140

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

MASK HOLE AS PER DWG

N/A
10.03.22

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

N/A
10.03.22

160



Packaging

Packaging

Identify as per dwg & Stock Location: 095

0.00

Memo

0.00

10/3/22 (8)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24
10-22-8
(8)

Picklist Print

March 15, 2010 1:27:40 PM

Page 1

Work Order ID: 56952

Parent Item: D3909-3

Parent Item Name: Fwd Lower Attach Arm

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP
Rev:B chg blank size in seq 100 DD 10.02.10 verified by:JLM

Start Date: 16/03/2010

Required Date: 26/03/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303B0.750X1.500		Purchased	No			100	f	10.9858	2.8067			



303 BAR .750" X 1.500"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

113310

10.98578157

10.9857816

MW
10/03/18

8

DART AEROSPACE LTD		Work Order: 56952
Description: FWD LOWER ATTACH ARM		Part Number: D3909
Inspection Dwg:	Rev: A	Page 1 of 1

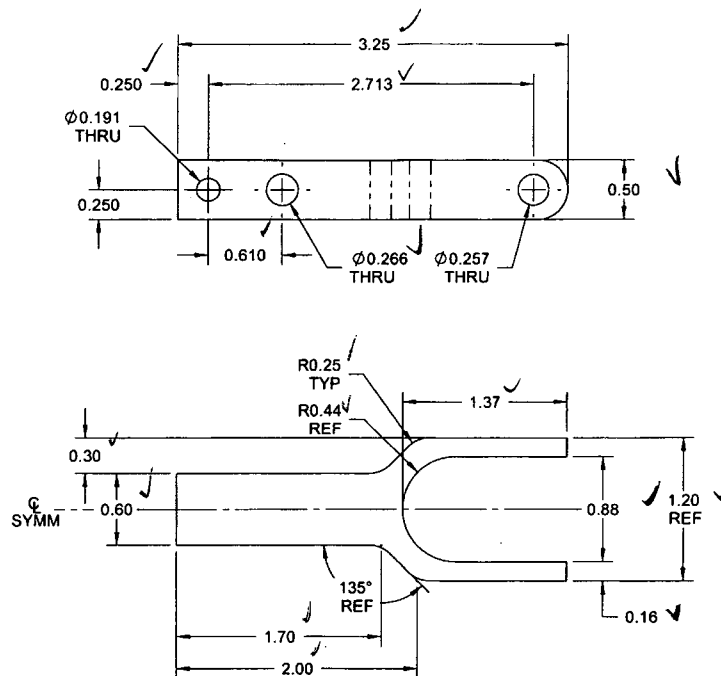
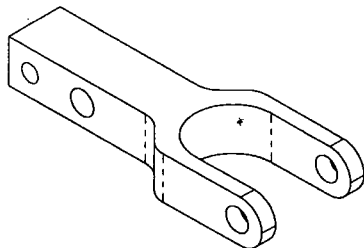
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.25	+/- .030	3.250	/			
.250	+/- .010	.248	/			
2.713	+/- .010	2.713	/			
.191	+ .005 - .001	.193	/			
.266	+ .006 - .001	.269	/			
.257	+ .006 - .001	.258	/			
.250	+/- .010	.251	/			
.610	+/- .010	.611	/			
.50	+/- .030	.501	/			
.30	+/- .030	.300	/			
R.25	+/- .030	R.25	/			
R.44	+/- .030	R.44	/			
1.37	+/- .030	1.37	/			
.60	+/- .030	.602	/			
.88	+/- .030	.878	/			
1.20	+/- .030	1.205	/			
135°	+/- 1/2°	135°	/			
1.70	+/- .030	1.70	/			
2.00	+/- .030	2.00	/			
.16	+/- .030	.162	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 10.9.20	Date: 10/03/20	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3909-3 FWD LOWER ATTACH ARM

56952

RELEASED
2010-03-12
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.	E	D3909	SHEET 4 OF 5
APPROVED	WJD	TITLE	SCALE
DE APPR.	WJD	FWD X-TUBE LUG ASSY	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	